

Date: Monday, 3/13/2006 7:30:57 AM
 User: Johnstan

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26217 -1
 Estimate Number : 11119
 P.O. Number : N/A
 This Issue : 3/13/2006 S.C. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run :
 Drawing Name : CLAMP
 Part Number : D30411
 Drawing Number : D3041 REV. A I
 Project Number : N/A
 Drawing Revision : A I
 Material : N/A
 Due Date : 3/30/2006
 Qty: 10 Um: Each
 Written by : SEE COMMENT BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est: A 01 07.11 New Issue SM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0875 f(s)/Unit Total: 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: B33779

J.G. 06/03/05 41

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion; 1.250" Long

J.G. 06/03/05 41

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

Issue P.O. = 00000893 A 06/03/05

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Monday, 3/13/2006 7:30:58 AM

er: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26217

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SPD 06/04/19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.0120" diameter hole

DC 06/04/22

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description

Batch

1 D2611 Bearing

B24769

SP 06/04/25 10

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

SP 06/04/25 10

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/04/25 10

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

06/04/25 (14)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 26217

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

10
SD 06/04/26

Job Completion



4 06.04.26



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

38

D3041-1

Clamp

0893 ✓

2/4/11
MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi (Regula) Walz

Vankleek Hill, April 11, 2006